Work Order ID 58506

May 7, 2010 3:04:34 PM



Page 1

Item ID:

D3935-4

Accept

Setup Start

Stop



Revision ID:

Pylon Wall Protector, RH Item Name:

Start Date: 07/05/2010 **Required Date: 24/05/2010**

Start Qty: 2.00

Reg'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 16-5-10 Tooling:

SPC (Y/N):

Date:

Date:

Code

Start

Run

Stop

Sequence ID/ Work Center ID

Operation Description .`

Date: _____

Set Up/ - 1 : Run Hours

Drawँ Number Rev.

Draw Plan

Accept Oty

Reject Reject Qty

Insp. Number

Stamp

Draw Nbr

Revision Nbr

В

QC:

D3935

100

Wateriet FLOW CNC Wateriet Memo

1-Cut as per Dwg D3935

Dwg Rev: Prog Rev:

0.00

0.00

2- Deburr if necessary

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

1810-5-11

B10-5-11

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** Approval DATE **STEP** PROCEDURE CHANGE Bv Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Disposition: _____ QA: N/C Closed: ____ Date: ____ Resolution **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B Description of NC Verification **Approval** DATE **STEP Approval** Sign & Initial **Action Description** Section A Section C Chief Ena QC Inspector Chief Eng Date Chief Eng

Work	Orde	r ID	58506
** W I	1/1 UIC	71 II.	-,7(1-,71111)

May 7, 2010 3:04:34 PM



Page 2

Item ID:

D3935-4

Accept



Setup Start



Revision ID:

Item Name:

Pylon Wall Protector, RH

Start Date:

07/05/2010

Start Oty: 2.00

Required Date: 24/05/2010 Reg'd Oty: 2.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: Date:

Date: SPC (Y/N):

Tooling:

Date: Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

120

OC

Ouality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ Run Hours

Draw Number

Draw Plan Rev. Code

Accept Otv

Reject Otv

Reject Insp. Number Stamp

130

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

0.00

0.00

140

Quality Control

Memo

0.00

QC 21

10/05/13 Pd PS/10-5-12 (2)

Dart Ae	rospace L	td						•		
W/O:			WC	RK ORDER CHANGI	ES		 ,			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					
	Reso	olution:	Disposition: Q			QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Chief Eng	QC Inspecto		
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Picklist Print

May 7, 2010 3:04:40 PM

Work Order ID: 58506

Parent Item:

D3935-4

Pylon Wall Protector, RH Parent Item Name:

Comments:

IPP RevA: New issue DD verified by:EC

Start Date: 07/05/2010

Required Date: 24/05/2010

Page 1

Start Qty: 2.00

Required Oty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04	1810 (1881 B)(1 1188188 (118 B)(1)	Purchased	No			100	sf	2,595.865		16.09		
GE PLASTICS LEXAN SH											1810-5-11	

GE PLASTICS LEXAN SHEET

Location	Loc Oty	Loc Code		~
MAT	2595.8658			(2)
111710	64			
112585	184.333			
114032	2347.5328		114032	

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ Resolution WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval** DATE STEP **Approval** Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

DART AEROSPACE LTD	Work Order:	58506
Description: Pylon Wall Protector, RH	Part Number:	D3935-4
Inspection Dwg: D3935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

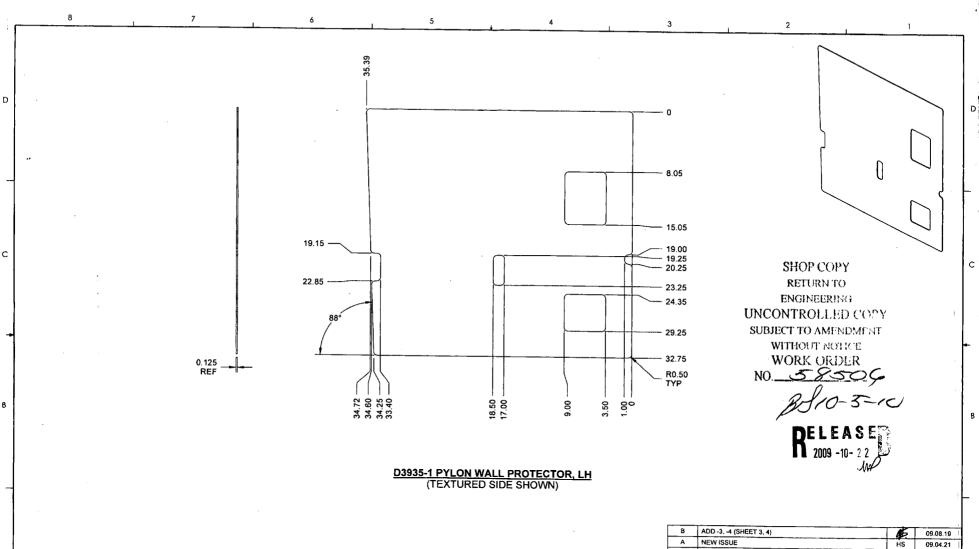
X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+/-0.030	83.2	4			
12.68	+/-0.030	13.68	×			
18.75	+/-0.030	18.75	**			
19.00	+/-0.030	19.00	4			
20.25	+/-0.030	20.0E	*			. ,
22.75	+/-0.030	27.75	8			<u> </u>
23.73	+/-0.030	2373	86			
28.63	+/-0.030	28.63	8			
32.75	+/-0.030	32,75	*			
1.00	+/-0.030	1,00	8		-	
3.50	+/-0.030	3,50	x			
9.00	+/-0.030	9.00	4			
14.70	+/-0.030	14.70	\$ 0			.,
16.20	+/-0.030	16.30	>			
33.40	+/-0.030	33.380	1			** /
34.25	+/-0.030	34.28	4			*** *******
34.60	+/-0.030	34.66	or			=
34.72	+/-0.030	34.77	7			•• • •
22.85	+/-0.030	22.85	n			
19.15	+/-0.030	19.16	X			
35.39	+/-0.030	35.39	×			
0.125	+/-0.010		>			· · · · · · · · · · · · · · · · · · ·

Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	10-5-11	Date:	10/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
_ A	09.11.17	New Issue	KJ KJ	111

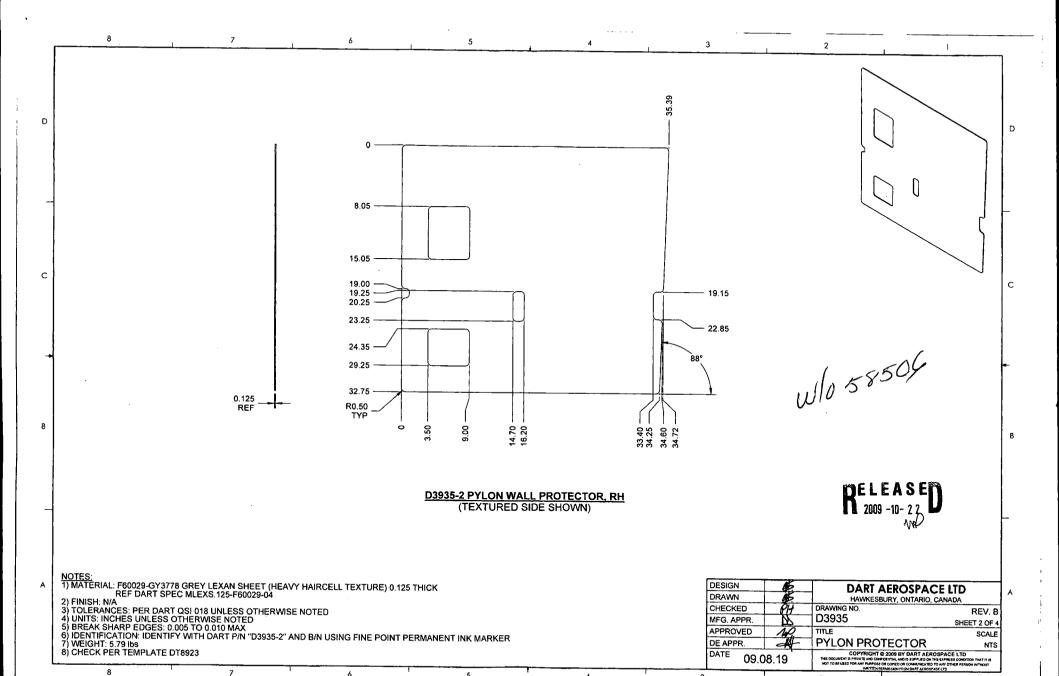
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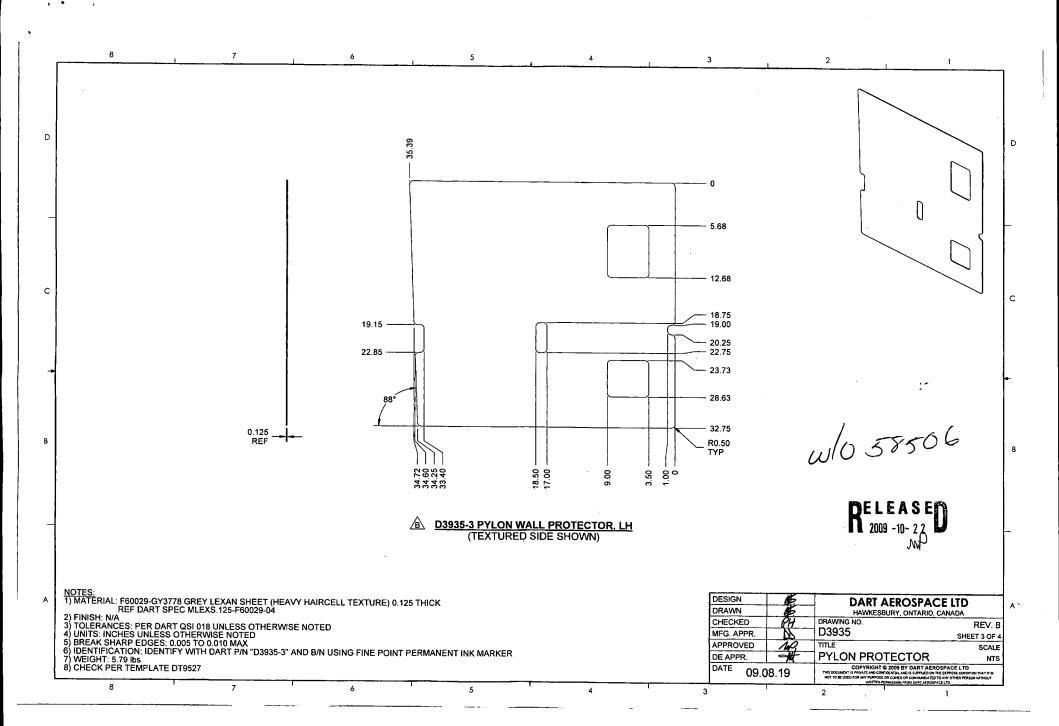
NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF, DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A 1/2 1/3 TOLERANCES: IPER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHESTUNLESS OTHERWISE NOTED
5) BREAK SHARP, EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION; IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 IDST
8) CHECK PER TEMPLATE DT8922

8	ADD -3.	-4 (SHEET 3,	4)	AS	09.08.19			
Α	NEW IS	EW ISSUE H			09.04.21			
REV.			BY	DATE				
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DRAW	N	15	HAWKESBURY, ONTARIO, CANADA					
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MFG. A	APPR.	<i>N</i>	D3935		SHEET 1 OF 4			
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DE AP	DE APPR.		PYLON PROTECTOR		NTS			
DATE	09.0	08.19	COPYRIGHT © 2009 BY DART AEROSPACE LTO THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IS NOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO TO ANY OTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO TO ANY OTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO TO ANY OTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE MOTHER PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOT TO BE USED FOR ANY PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOTHER PURPOSE OF COMPANIANT TO THE PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOTHER PURPOSE OF COMPANIANT TO THE PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOTHER PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOTHER PURPOSE OF COMPANIANT TO THE PERSON WITHOUT MOTHER PURPOSE OF COMPANIANT TO THE P					

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

.D 5.68 -12.68 С . 18.75 – 19.00 -- 19.15 20.25 22.75 23.73 -28.63 wlo 58504 0.125 R0.50 REF TYP 08 3.50 33.40 34.25 34.60 34.72 9.00

(TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP, EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION (IDENTIFY WITH DART P/N "D3935-4" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 IDENTIFY
8) CHECK PER TEMPLATE DT9528

7

DESIGN		DART AEROSPACE LTD					
DRAWN	45	HAWKESBURY, ONTARIO, CANADA					
CHECKED	PH	DRAWING NO.	REV. B				
MFG. APPR.	177	D3935	SHEET 4 OF 4				
APPROVED	10	TITLE	SCALE				
DE APPR.	-#	PYLON PROTECTOR	NTS				
DATE 09.0	08.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT B PRIVATE AND COMPOUND AND AND AND AND AND AND AND AND AND A					

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W/O:				WC	RK ORDER CHANG	iES			
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	ne							Date: _	
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DATE	Section A		Initial Action		Sign Date	Section C	Chief Eng	QC Inspecto	
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